



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3641-1

Job Sheet 171367



Part No: D3641-1

Job Qty: 8 ea

Part Name: Cover



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/31/18

Job Tracking No:

Due Date: 1/31/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	1/30/18	1/30/18	0.00	0.00	Start Up Waterjet		5-18/02/03
100	Waterjet	8 pcs	1/30/18	1/30/18	0.00	0.65	Waterjet1		5-18/02/03
110	QC	8 pcs	1/30/18	1/30/18	0.00	0.00	QC2 Waterjet-2		5-18/02/03
120	QC	8 pcs	1/30/18	1/30/18	0.00	0.00	QC8-3		38
130	Brake NC	8 pcs	1/30/18	1/30/18	0.06	0.56	Brake NC 1		38
140	QC	8 pcs	1/30/18	1/30/18	0.00	0.00	QC5		38
150	HandFinish	8 pcs	1/31/18	1/31/18	0.00	0.46	HandFinish1		18-02-88
160	QC	8 pcs	1/31/18	1/31/18	0.00	0.00	QC7-2		38
170	Packaging	8 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3-1	51234A	57L
180	QC21-SA	8 Ea	1/31/18	1/31/18	0.00	0.00	QC21		21

FEB 1 2 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.032	5052-H32 .032 Sheet	6.3896 sf (.7987 ea)	90-Start up Operation	
	M135016	6.8		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M5052H32S.032	6	1	0

Part Specifications

Specifications could not be found.

Plex 1/31/18 11:41 AM Dart.Gagnon.Michelle

DART
AEROSPACE
S038817

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Cover

PART NO: D3641 – 1

Original Serial #: S038817

Revision:

Operation: Start up Operation 02/04/18

Change No:

Job No: 171367

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

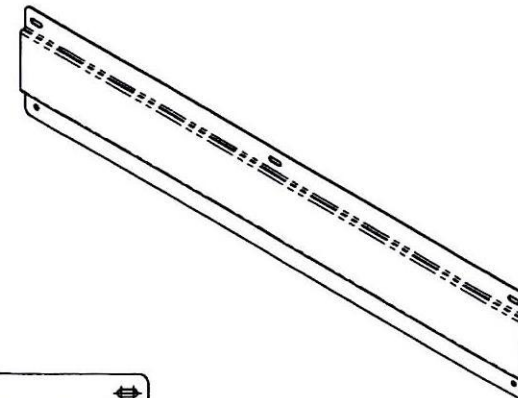
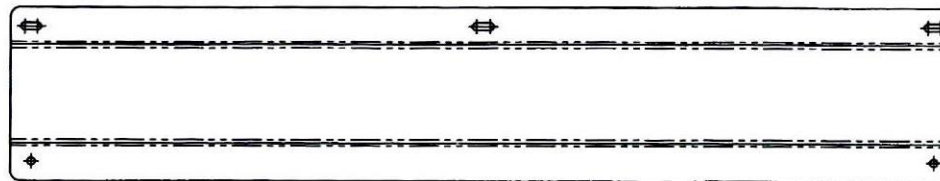
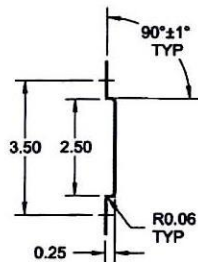
DART AEROSPACE LTD		Work Order: 171367
Description: Cover		Part Number: D3641-1
Inspection Dwg: D3641	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	0,191	1		UDC-02	
0.191	+/-0.010	0,194	1		Tape	
0.37	+/-0.030	0,374	1			
0.54	+/-0.030	0,545	1			
0.69	+/-0.030	0,693	1			
11.86	+/-0.030	11,867	1			
12.22	+/-0.030	12,22	1			
23.37	+/-0.030	23,37	1			
23.54	+/-0.030	23,54	1			
23.69	+/-0.030	23,69	1			
24.06	+/-0.030	24,07	1			
0.50	+/-0.030	0,505	1			
4.28	+/-0.030	4,287	1			
4.78	+/-0.030	4,782	1			
0.032	+/-0.010	0,032	1			

Measured by: SC	Audited by:	Preliminary Approval:
Date: 18/02/03	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	12.03.08	Dwg Rev updated	KJ	



D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)
 (MAKE FROM D3641-1F FLAT PATTERN)

RELEASED
 2009-11-18

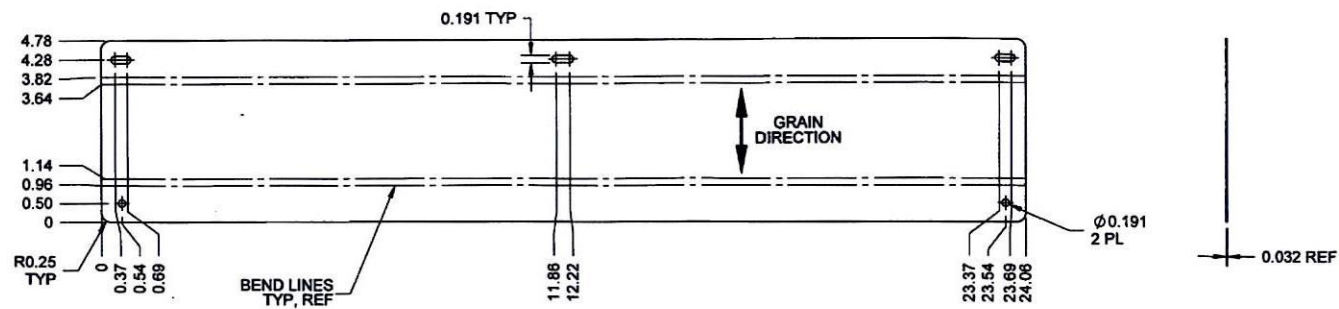
NOTES:

- 1) MATERIAL: D3641-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

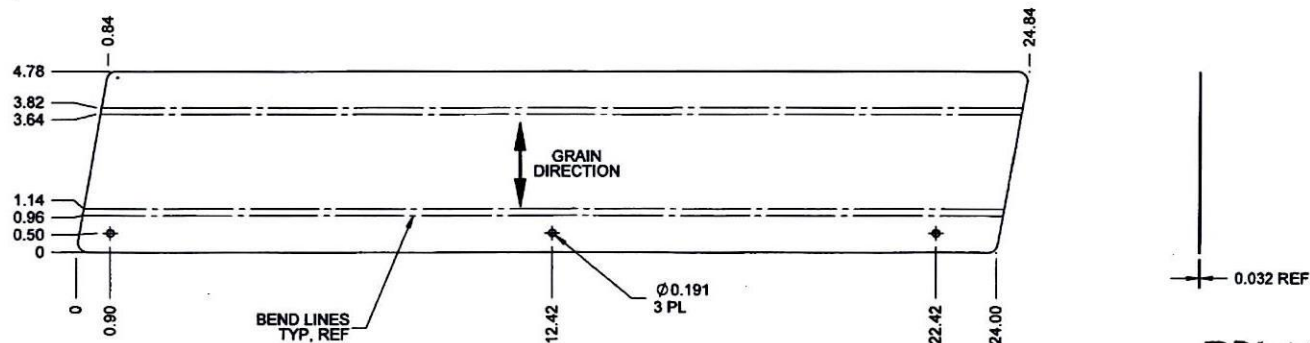
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
 NO. 171367

JAN 30 2018

C	REFORMAT DRAWING TO CURRENT STANDARDS; D3641-3 WAS -4 (2N C4-2); ADD D3641-4 VIEW (2N A4-2); MOVE -1F/3F FLAT PATTERN TO SHEET 3, PER NCR 09-076	RF	09.10.02
B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	09.10.02	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3641-1F FLAT PATTERN



D3641-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1F/-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
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RELEASED
2009-11-10